ELECTRODE WIRE FOR WIRE ELECTRIC DISCHARGE MACHINING

Patent number:

JP61270028

Publication date:

1986-11-29

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Classification:

- international:

B23H7/08; B23H7/08; (IPC1-7): B23H7/08

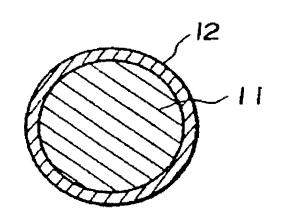
- european:

Application number: JP19850113685 19850527 Priority number(s): JP19850113685 19850527

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Abstract of JP61270028

PURPOSE:To improve a machining speed of an electrode wire and its break resisting property, by coating a steel wire core material, having a 10-70% coating rate of copper, with a 0.1-15mum thick copper-zinc alloy layer of mean zinc concentration of 10-50% by weight so that concentration of zinc increases higher toward the surface layer. CONSTITUTION:A copper coated steel wire 11 coats a steel wire with copper by a coating rate of 10-70%. The copper coated steel wire 11, providing in its peripheral surface with the wire 11 being as a core material a copper-zinc alloy layer 12 in a range of 0.14n15mum almost fixed thickness, forms the whole unit in about a 0.2mm diameter. The copper-zinc alloy layer provides means concentration of zinc in 10-50% by weight while a gradient of concentration so as to increase the concentration of the zinc higher from the copper ground toward the surface layer. While the steel wire 11, heat treating a zinc layer provided in a uniform thickness by zinc electroplating to be completely changed into the copper-zinc alloy layer, enables the copper-zinc alloy layer 12 almost in a uniform thickness to be obtained.



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